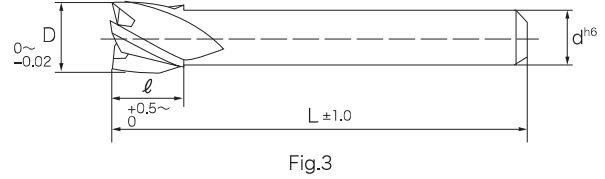
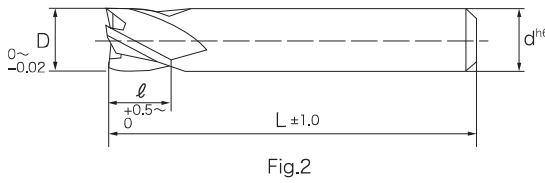
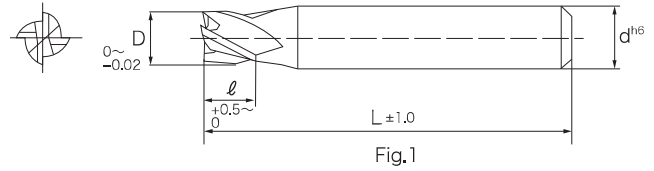


# IC4EAV



## (ザ・) カットミル 超硬4枚刃自動旋盤用エンドミル

Coated Solid Carbide Square Endmills for Automatic Lathes (4Flutes)



### 特長 Feature

- 刃長、全長が短く、自動旋盤用での使用に最適
- 刃径φ10以下のシャンク径はφ6でER11コレットで使用可能
- 新しいVcコーティングは従来のV1 (TiAlNコーティング) に比べ高い硬度(約3000HV)と酸化開始温度(約900℃)により更に長寿命
- Coated solid Carbide Square Endmills for Automatic Lathes (4Flutes)
- Since The blade length and overall length are short, it is ideal for use with automatic lathes.
- Products with a blade diameter of φ10 or less have a shank diameter of φ6, so they can be used for ER11 collets.
- The hardness of the VC coating is about 3000hv, which is harder than the conventional V1 coating, and the oxidation start temperature is about 900℃, so it is even more durable.

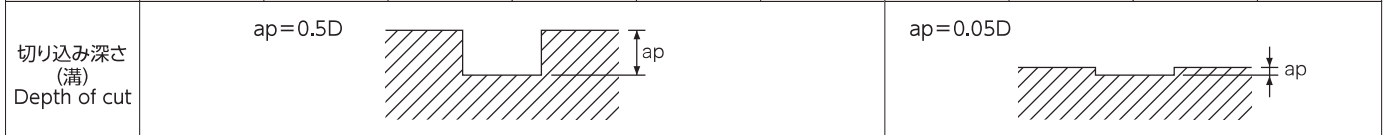
単位: mm

| 商品コード<br>Item Code | D  | ℓ | L  | d  | Fig. |
|--------------------|----|---|----|----|------|
| IC4EAV 3.0         | 3  | 6 | 35 | 4  | 1    |
| IC4EAV 4.0         | 4  | 6 | 35 | 4  | 2    |
| IC4EAV 5.0         | 5  | 6 | 35 | 6  | 1    |
| IC4EAV 6.0         | 6  | 6 | 35 | 6  | 2    |
| IC4EAV 7.0         | 7  | 6 | 35 | 6  | 3    |
| IC4EAV 8.0         | 8  | 6 | 35 | 6  | 3    |
| IC4EAV 10.0        | 10 | 6 | 35 | 6  | 3    |
| IC4EAV 12.0        | 12 | 6 | 35 | 10 | 3    |

※「D」については14、16、20もスローアウェー式でご用意しております。  
For "D", we also have 14, 16 and 20 with replaceable cutting edges.

### 標準切削条件表 Recommended cutting conditions

| 被削材<br>Work | 一般構造用鋼/炭素鋼/鋳鉄<br>S50C, S540C, FC250 |                   | 合金鋼/工具鋼<br>SCM, SKD, SKS |                   | プリハードン鋼(38~45HRC)<br>SKD61, SK, NAK |                   | ステンレス<br>SUS304, 316 |                   | 高硬度鋼(45~55HRC)<br>SKD61等 |                   |
|-------------|-------------------------------------|-------------------|--------------------------|-------------------|-------------------------------------|-------------------|----------------------|-------------------|--------------------------|-------------------|
|             | 回転速度<br>n(n/min)                    | 送り速度<br>F(mm/min) | 回転速度<br>n(n/min)         | 送り速度<br>F(mm/min) | 回転速度<br>n(n/min)                    | 送り速度<br>F(mm/min) | 回転速度<br>n(n/min)     | 送り速度<br>F(mm/min) | 回転速度<br>n(n/min)         | 送り速度<br>F(mm/min) |
| 3           | 8,800                               | 560               | 7,200                    | 285               | 5,000                               | 130               | 3,400                | 230               | 3,080                    | 80                |
| 4           | 6,600                               | 475               | 5,400                    | 260               | 3,750                               | 130               | 2,550                | 185               | 2,310                    | 80                |
| 5           | 5,300                               | 425               | 4,300                    | 240               | 3,000                               | 130               | 2,040                | 160               | 1,850                    | 80                |
| 6           | 4,450                               | 425               | 3,600                    | 235               | 2,500                               | 130               | 1,720                | 140               | 1,550                    | 75                |
| 7           | 3,800                               | 425               | 3,100                    | 230               | 2,150                               | 130               | 1,520                | 130               | 1,320                    | 75                |
| 8           | 3,300                               | 410               | 2,700                    | 230               | 1,900                               | 130               | 1,380                | 125               | 1,150                    | 70                |
| 10          | 2,650                               | 390               | 2,150                    | 230               | 1,500                               | 130               | 1,170                | 125               | 955                      | 70                |
| 12          | 2,200                               | 390               | 1,800                    | 230               | 1,250                               | 130               | 970                  | 115               | 795                      | 60                |



※切削条件はあくまでも目安です。使用される機械、チャックの剛性や切削油等の状況によって変動致します。

These conditions are for general guidance. Therefore they are subject to change to the situation of the machine used, the tool hold rigidity, cutting oil, etc.